

DART AEROSPACE LTD.	Work Order :	20657		
Description: 206L / 407 Step Assy, LH	Part Number:	D2724-041		
Drawing: D2724 Rev. B	Qty:	10		

Step	Location	Procedure	Ву	Date	Qty
1	EXPEDITING	Open W/O	#	04.04.01	10
2	METAL	Cut D2724-1 using D2622 extrusion as per Dwg D2724 Batch No. 6/596/	5B.	Hluglez	(3
3	METAL	Deburr and bevel ends for welding	36/	0 4/04/22	ري _
4	STORES	Pick: Oty Part Number Description Descrip	as.	64/05/bg	10
5,	QC	Inspect for foreign object per QSI 024	刎	04/05/65	10
6	WELDING	Weld end caps and lugs as per Dwg D2724 using Jig DT 8130 followed by Jig DT 8134	AS	01/05/05	(U
7	METAL	Grind end cap welds flush	513	offosto	10
8	QC ~~	Inspect Level 9	18	04-05-11	
9	QC	Inspect Level 5	B	c4.U5.11	10
10	FINISHING	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3.	M	0/05:11	10
11	QC	Inspect Level 3	A	64.05-11	10
12	METAL	Wing Walk per Dwg 2724 and QSI 005 4.4	2	4.05.13	10
13	QC	Inspect Level 3	M	Q1 05 13	10
14	STORES	Bag and tag	M	45 13	10
15	EXPEDITING	Close W/O; Cost / Part 68.71 Syc of /os/20 (10)	K)	04.05.19	10

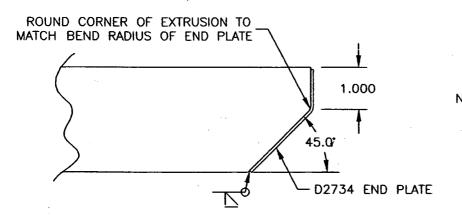
Rev	Date	Change	Revised By	Approved
A	98.04.16	New Issue	KB	
В	98.09.30	Reorder, Update Inspections	CP	
С	98.11.23	Added Inspections	DM	
D	00.07.20	Added Inspection for QSI 024	EC	
E	00.11.01	Removed P/O for powder coat – in house process	EC	L

RELEASED

Dart Aerospace Ltd

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Work			WORK (ORDER CHANGES	\$					
Order: DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
		-								
NCR			WORK (ORDER NON-CON	FORM	ANCE				
DATE	STEP	Description of NC section A	Intial	Corrective Act Section B	on .	Sign & Date		ication etion C	Approval Design Mgr	Approval QC Inspector
		DAD#.		Foult Catagon	<u> </u>	DO	A:		Date:	
NOTE: Date	& initial all entr	PAR#:		Fault Category:	Q	DQ. A: N/C CI	\		Date:	(



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004





TYPICAL STEP END DETAIL B			(Saus)	2
MEASURED BEFORE END CAPS WELDED IN PLACE		₪ >	CHECKED DATE 98.10.19	A Moisso
B 82.21 DISTANCE TO PLATE CENTER LINES AT TOP	APPLY BLACK ANTI-SKID ON - TOP SÜRFACE TO BOTTOM	97.12.04 98.10.19	APPRÓVED	DRAWN BY
D2724-041 LH. STEP ASSEMBLY (SHOWN) D2724-042 RH STEP ASSEMBLY (OPPOSITE) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WELD PER DART QSI 004 UNLESS OTHERWISE NOTED FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 006 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4	SHOP COFT RETURN TO RETURN TO ENGINEERING SUBJECT TO AMENDME WITHOUT MOTICE WITHOUT MOTICE OF WITHOUT	NEW ISSUE UPDATED WELD DETAIL REVISED TOLERANCES	DRAWING NO. REV. B D2724 SHEET 1 OF TITLE SCALE 206L/407 STEP ASSEMBLY NTS	DART AEROSPACE USA, INC.

Job Costing Report

Dart Aerospace Ltd.

Apr 01, 2004 02:23 pm

Hawkesbury

Work Order No

: 0020657

: D2724-041 Project Name Project For : WK416

Work Order Type : Main

Main WO Number

House Part Number : D2724-041 Description : 206L Step Ass'y

Manufactured : Yes

Amount Req'd : 10

Amount Done : 0
Start Date : 04-01-04

Est Finish Date : 04-14-04

Act Finish Date Drawings Reqd : No

Ok for Approval : Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	٧ar. %	Posted	To Post
=======================================	==:					
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	·	
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		14 A
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		=======	========	======		
Burden	:	0.00	0.00	0.00		(· .
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Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000			
Selling Cost	:	0.00	0.00			
<u> </u>			•			

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) 0.00 0.00